

Ship Nov. 6th

Date: Tuesday, 04/11/2008 10:59:54 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: "T" HANDLE ASSEMBLY		
Job Number	: 43185					
Estimate Number	: 11179					
P.O. Number	:			Part Number	: D2282041	
This Issue	: 04/11/2008	S.O. No. :		Drawing Number	: D2282 REV E	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: LARGE FAB ASSY		
Previous Run	: 42434			Drawing Revision	: E	
Written By	:			Material	:	
Checked & Approved By	:			Due Date	: 11/11/2008	
Comment	: Est Rev:A			Qty:	5	
	Removed from 9 Digit			Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D22823	Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Pick:	
	Qty Part Number	Description Batch	
	1 D2282-3	Handle tube <u>41889</u>	
2.0	D22825	Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Pick:	
	Qty Part Number	Description Batch	
	1 D2282-5	Handle tube <u>341890</u>	
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	

Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-041 'T' Handle Assembly
 Grind chamfers and ensure full penetration as per dwg D2282
 *****brush weld right after welding, to take color off*****

A/R ER316L SS Filling Rod M101744
 Dwg Rev: E

(x5)

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Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/11/08 (5)

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

8-11-5

(X5)

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S08/11/08 (X5)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



(X5)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 25

8/11/08

(X5)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/08 (X5)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

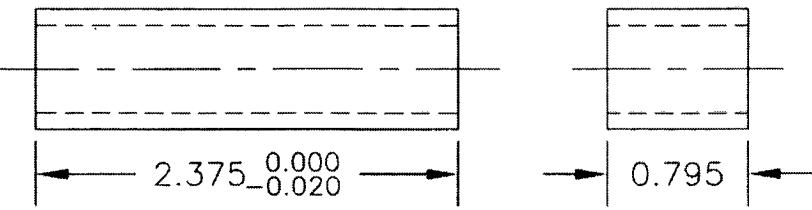
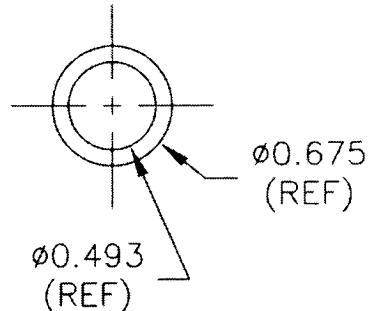


MF 08-11-05

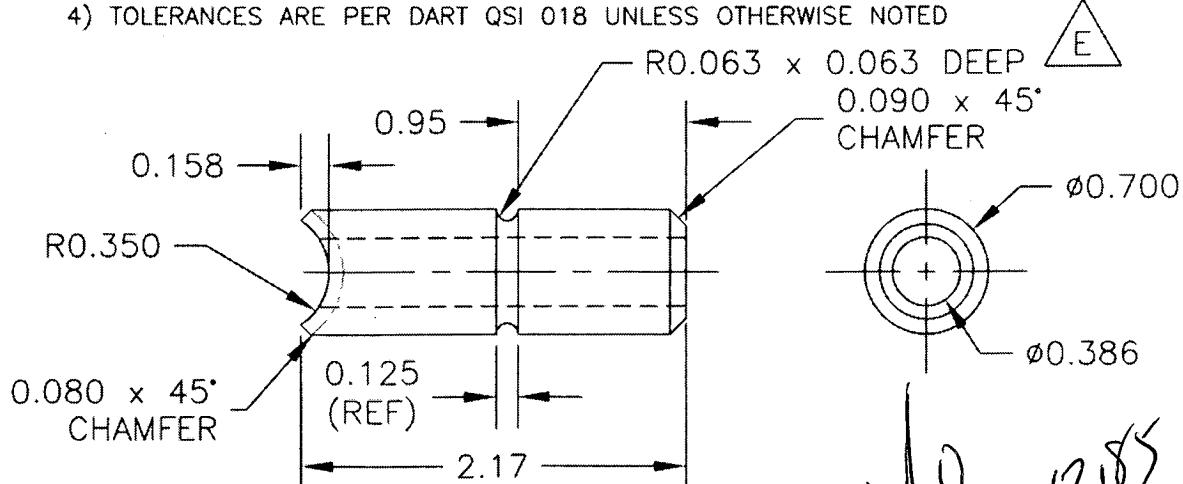
DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Initials]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1

RELEASED
6/09/16

D2282-3 D2282-7D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 D2282-5

W/0 4/3/85

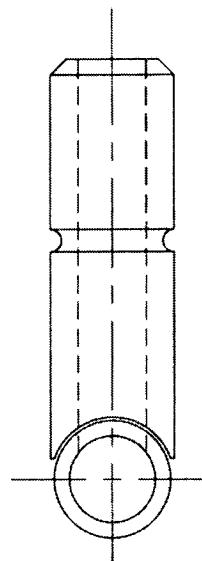
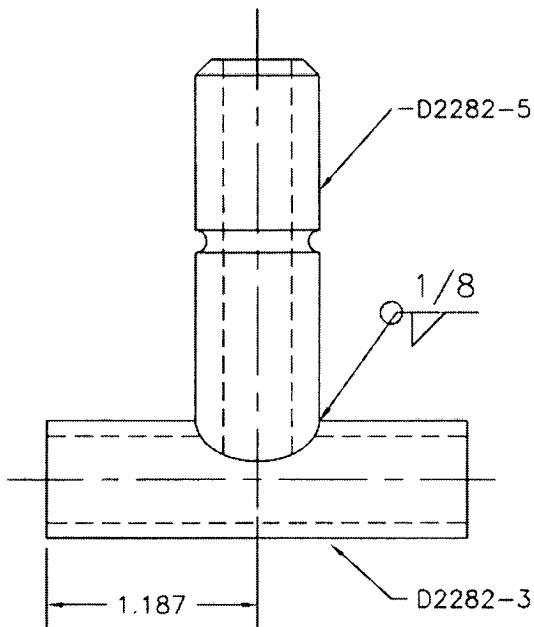
D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

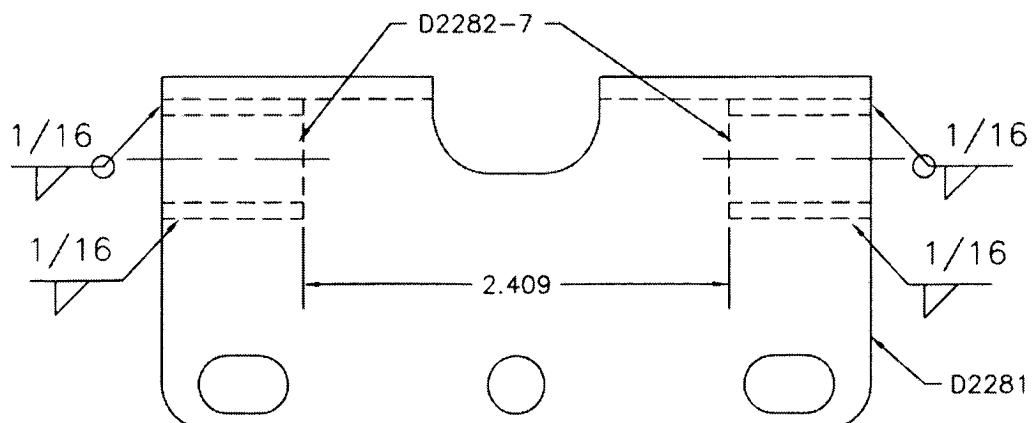
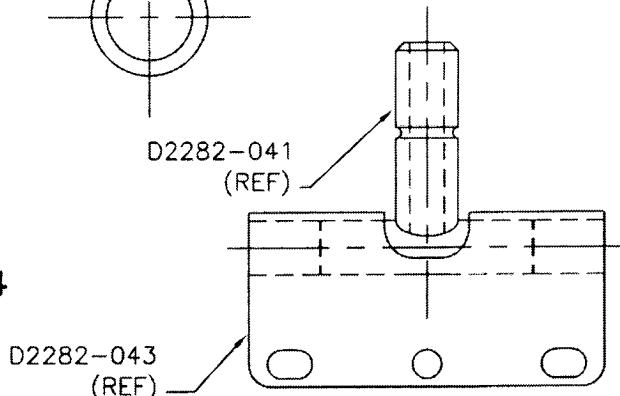
E

DART

DESIGN BW	DRAWN BY <i>RP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>WRC</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



REBAGED
05/09/16



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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